



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-42121W6-1
Job Sheet 203528



Part No: RBE105-42121W6-1

Job Qty: 2 pcs *MLL*

Part Name: Staking Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/21/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 12/30/19

Type: **SOLD**

Description:

Note: **DWG** RBE105-42121W6 REV.1 IPP Rev. A 19.10.29 New issue DP Verify DD

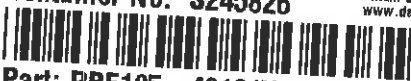
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time		
100	Small Fab - 1	2 pcs	12/30/19		0.00	0.17	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
110	QC 5	2 pcs	12/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
QC 5 - 40									
QC 5 - 61									
QC 5 - 81									
120	Outsource - 13 - Zinc Plating	2 pcs	12/30/19				GRO002-VC 5		DAS JAN 08 2020 9-89 2020-01-08
130	Packaging 2-1 - Receive - B4B	2 pcs	12/30/19		0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		



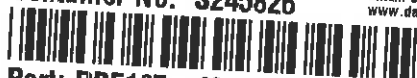
Container No: S245826

Part: RBE105-42121W6-1
Job No: 203528
Serial No/Batch: S245826
Revision: 1
Inspector:
Exp Date:
Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 832-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/08/20



Container No: S245826



Part: RBE105-42121W6-1

Job No: 203528

Serial No/Batch: S245826

Revision: 1

Inspector:

Exp Date:

Instructions:

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1270 Aberdeen Street
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TEL: 1 613 632-5200
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Date: 01/08/20

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				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	<i>JE</i> JAN 15 2020
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
140 QC 6	2 pcs	12/30/19	0.00 0.00		JAN 15 2020 <i>DAS</i> 68
160 Packaging 3-1 - Stock - B4B	2 pcs	12/30/19	0.00 0.00	Packaging 3 - 1 - B4B	<i>9-89</i>
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	<i>DAS</i> 28
				Packaging 3 - 5 - B4B	<i>9-89</i>
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
170 QC 21 - SA	2 pcs	12/30/19	0.00 0.00	QC 21 - SA - 21	<i>DAS</i> 21
				QC 21 - SA - 70	<i>9-89</i>
				QC 21 - SA - 53	JAN 16 2020

Part Op 100 - 1-Assemble as per DWG. 2-Apply LPS-3 to ALL steel parts

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - Issue P/O : *45517* -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required

130 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)

140 - (QC6- All purchased or subcontracted products)

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

GA137A

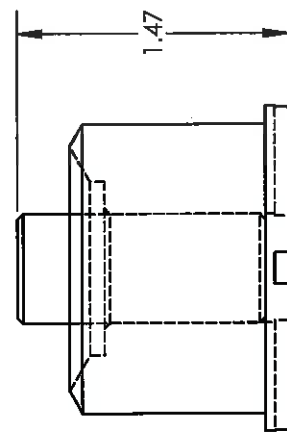
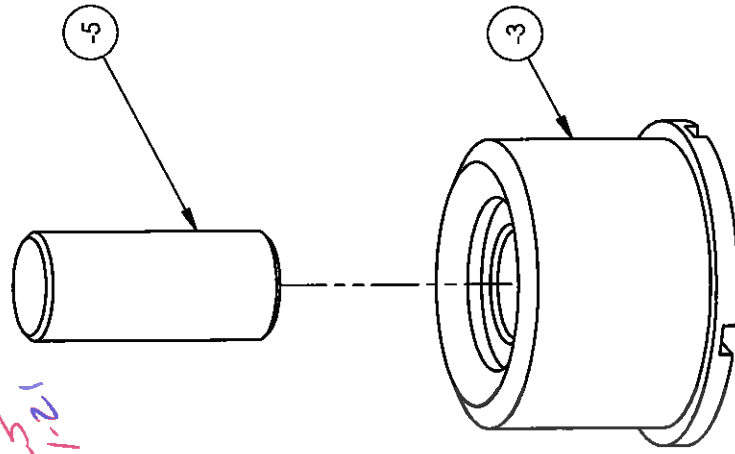
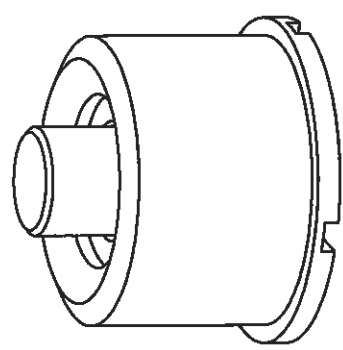
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RBE105-42121W6-3	Staking Insert	7/2 pcs (1 ea)	100-Small Fab - 1	5240383
RBE105-42121W6-5	Guide Pin	7/2 pcs (1 ea)	100-Small Fab - 1	5237395
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBE105-42121W6-3	2	0	0
	RBE105-42121W6-5	2	0	0
Part Specifications				
Specifications could not be found.				

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SHOP COPY
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 203528
 8/11/21

REVISIONS		DESCRIPTION		REV	ECR	DATE	INITIAL	APPROVED



STAKING TOOL	
TITLE	
DWG NO.	RBE105-42121W6-1
REV	1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/16 DECIMALS ± .005 ANGLES ± .1° SURFACES = 125/	
XXX ± .005 XX ± .01 X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL	
EC145	
APPROVED:	GILBERT
DATE	1/20/2016
SCALE	1:1
SHEET 2 OF 4	

(1)
 STAKING TOOL ASSEMBLY

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐			DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐						Date: _____ Sequence #: _____ QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition												
Root Cause Operator ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐		FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Other/Details: _____								Completed By Lead hand / Supervisor QC / QA Coordinator		Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐		



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045517



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045517

PO Date: 1/8/20

Due Date: 1/16/20

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

2020-01-10

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	203528	RBE105-42121W6-1	RBE105-42121W6 Rev 1	Staking Tool Assembly -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required	Firmed X7	-	1/16/20	7 pcs	0 pcs	7 pcs	\$7.1428/pcs	\$50.00
												JAN 15 2020
2	203755	RBE117-66021W13-3	RBE117-68021W13 Rev 1	Impact Weight -Issue P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 1018 -Certificate of Conformity is required	Firmed X7	-	1/16/20	7 pcs	0 pcs	7 pcs	\$7.1428/pcs	\$50.00
												JAN 15 2020
Grand Total:												\$100.00

Guerin



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PURCHASE ORDER

POHB045517



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/10/20 3:06 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(025311-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

025311 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
10-Jan-2020		Jigar Patel		POHB045517				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE105-42121W6-1 Rev.1	RBE105-42121W6 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	7	7	0	0	0
2	RBE117-68021W13-3 Rev.1	RBE117-68021W13 01-ZINC-CLEAR TRI [ZINC CLEAR TRIVALENT] 24 HRS AS PER ASTM B633 TYPE - 1, SC - 2 0.0003 "	ZINC CH	7	7	0	0	0

RECEIVED

JAN 14 2020

DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.